\*101533\*

Page 1

Revision ID:	D3915-041	emby, Long Basket		Accept	*N900	<b>040</b>	100	)*	Setup S	Start Stop	*NS	31*
Start Date: Required Date:	5/09/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				•	"IVIS	S2*
Reference:			•									
Approvals:	Process Pla	in: MLT	Date: 13-05	Tooling:	Da	ate:				Start	*NF	₹1*
	QC:		Date:	SPC (Y/N):	Da	ate:			\$	Stop	*NF	₹2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Reject Qty		eject umber	Insp. Stamp
Draw Nbr	Rev	vision Nbr										
D3915	_e_	E	13.10.31									
100		Weld per dwg A/R A		0.00		~ - ~				DAS	<u>,                                      </u>	· · · · · · · · · · · · · · · · · · ·
*100*		Large Fab	4175	<b>29</b> /					1.	43	ر چ :	x = 173
Large Fab		Memo		0.00						9. <del>6</del> 3		, * <del>,</del> .
Large Fab		D4019-3, Then weld with weld ****DO1	weld top and bottom then d remaining sides of D4014 NOT WELD THE (4) COR AP TO GET THE ACID A	D3915 using DT9606A. When make a small hole in the weld p-3 Rib. Let it cool down, the ENERS. GRIND OFF CORNEND ALODINE OUT OF BAS	d to let air out. n block holes ERS TO HAVE							
		2- weld h	inge, label plate and Moun	ting plates as per dwg D3915								
110		QC9- Inspect visual p	er QSI004- Fusion Welds	0.00								DAS
*110* QC Quality Control		Memo		0.00					13-	ji.Œ	<u> </u>	9 9-89

										DQA:	Date:	, ,
NCR: Y	es / No				WORK ORDER NON-O	COI	NFOR	MANCE / UPDA	ATE	QA Closed:	 Date:	
Work Orde					DISPOSITION				AGAINST DE		/PROCESS	
Part N	lo		-,		Rework Scrap Use-as-is		Thern	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update	ן נ		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update		nitial	Actio	n	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descrip	tion	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling			1									
Operator												
Material												
Setup												
Other												
Process		2 - 2										
Supplier				i i								
Training		* '										
Unapproved												
					F	AUL	T CATE	GORY				
Landi	ng Gear				General		_			_		_
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	Not Conce	ntric to	o/s	BOM/Route		Hardwa	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
	Crushed	/Crimped			Burrs		Instruct	tions Incomplete/Un	clear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Г	Mainte	enance		Part Moved		_

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

# \*101533\*

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Item ID: Revision ID: Item Name:	D3915-041 Light Lid As	ssemby, Long Basket		Accept	*N900	<b>040</b>	100	ገ* s	Setup Star	IV	S1* S2*
Start Date: Required Date:	5/09/13 : 5/13/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					
Reference:							-	R	Run Star	t 44.	
Approvals:	Process P	lan:	Date:	Tooling:	Da	ate:		•	Stop	!//	R1^
	QC:		Date:	_ SPC (Y/N):	Da	ate:			Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		QC5- Inspect part comp	leteness to step on W/O	0.00							DAS
*1'20* QC Quality Control		Memo		0.00					13-11-5	೨	9-89
130		Chemical Conversion Co	oat per QSI005 4.1	0.00				/·	21/	3 7 /3-1	1/9
*130* HandFinish		Memo	DE TO DINCE CAREFUL	0.00	*				M	7 /0"	(
Hand Finishing  140  *140			uminum rod Batch:	LY ACID AND ALODINE**				,	v DĀ	5 13	- //- //
Large Fab		Memo		0.00				/	√ <u>9-8</u>	3 —/- <i>O</i> _	
Large Fab		1- weld (4)	corners								

NCR:	Yes	/	No

												· / >
										DQA:	Date:	, ,
NCR: Y	es / No				WORK ORDER NON-	CO	VFORM	MANCE / UI	PDATE	QA Closed:	Date:	
Work Orde	er:				DISPOSITION				AGAINST DI	EPARTMENT	PROCESS	
					Rework	٦		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.				Scrap	1		Machining	Small Fab	Proc	d. Eng. Coor.	Quality
					Use-as-is	1		noforming	Finishing		e/Packaging	Other
NCR N	lo.				Work Order Update	7 1		Large Fab	Composite	1	Supplier	
						_				<b>-</b>		
Root				Descri	ption of work order update	Ī	nitial	А	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector
Ooc/Data												
quip/Tooling	<u> </u>							<b>,</b>				
Operator	÷											
Material			]									
etup												
Other												
Process	_											
Supplier			1									
raining												
Jnapproved												
·						FAUL	T CATE	GORY			<del>.</del>	
Landii	ng Gear			_	General		1		_	<b>-</b>	<b>r</b>	<b>,</b> , ,
	Bendin	-		. –	Bend	-	Grain		<u> </u>	Ovalized		Pressure/Forced
		Not Conce	ntric to (	o/s	BOM/Route	-	Hardwa		<u> </u>	Over/Under	ļ	Temperature/Cure
	Cracks			ļ	Broken/Damaged	-	4	on Incomplete	<u> </u>	Part Incorred	<u> </u>	Weld
		d/Crimped		<u> </u>	Burrs	$\vdash$	-1	ions Incomplete	e/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination	-	Mainte		ļ	Part Moved		
		eat g 💆			Countersink	-	Mislabe		<u> </u>	Positioned V		ا ا
	<del></del>	ion Strip ir	ı Tube	<u> </u>	Cut Too Short	$\vdash$	Misread	1	L	Power Loss/	Surge	Other
	<b></b>	in Bend	-	<u> </u>	Drill Holes	$\vdash$	Offset	outtle coat				
	<b></b> -	Waves in		ີ	Drawing	$\vdash$	-	Calibration				
		Sequence		<b> </b>	Finish	$\vdash$	-	Sequence				
	Wave/	Twist in Tu	be		Folio	1	Outside	Dimensions				1

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

\*101533\*

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May-13-13 1:04:11 PM

Item ID: Revision ID:	D3915-041			Accept	*N900	<b>040</b>	100	)*	Setup S	Start Stop	*N:	S1*
Item Name: Start Date: Required Date: Reference:	5/09/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	ID:				<b>эсор</b>	^N:	S2*
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:				Start Stop		R1* R2*
Sequence ID/ Work Center I	D	Operation Description QC9- Inspect visual per	QSI004- Fusion Welds	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	t Rejec Qty		Reject Number	Insp. Stamp
*150* QC Quality Control		Memo		0.00					<u> </u>		-	09 2.89 ———
155		QC6- Inspect dimension	s to drawing	0.00					,			(DAS)
*155* QC Quality Control		Memo	fit of lid with base***	0.00					13-11-	77		
157		Chemical Conversion C		0.00								
*157* HandFinish Hand Finishing		Memo 1- realodine		0.00				_1	Х		H	13/K/12

											DQA:	Date	:
NCR:	⁄es	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPD	ATE		·	
											QA Closed:	Date	•
Work Orde	\					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Work Oru	-					Rework	7		Skid-tube	Crosstube	]	Water Jet	Engineering
Part I	J۸					Scrap	1	•	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
raiti	•0.					Use-as-is	1		noforming	Finishing	1	e/Packaging	Other
NCR I	٩o					Work Order Update	1	1	Large Fab	Composite	1100/3101	Supplier	1 <b>J</b> iiii H
	٠٠٠.						J				ı		
Root					Descri	ption of work order update		Initial	Acti	on	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator			Ì										
Material													1
Setup													
Other							1		;				
Process			İ		į								
Supplier													
Training													
Unapproved													
							AU	LT CATE	GORY		· · · · · · · · · · · · · · · · · · ·		
Landi	ng (	Gear				General		- <b>-</b>			-		
		Bending				Bend	L	Grain			Ovalized	L	Pressure/Forced
		Centre N	ot Concei	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct _	Weld
		Crushed/	Crimped			Burrs		Instruct	tions Incomplete/U	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved
Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Item ID: Revision ID:	D3915-041			Accept	*N900	040	100	<b>)*</b> s	Setup St	art	*N	S1*	
Item Name:	Light Lid Ass	semby, Long Basket							St	top	*N.	52*	
Start Date:	5/09/13	Start Qty: 1.00	*1*		Cust Item	ID:							
Required Date	: 5/13/13	<b>Req'd Qty:</b> 1.00	*1*		Customer:								
Reference:			· ·						_				
Approvals:	Process Pl	an:	Date:	Tooling:	D	ate:		F		tart	*N	R1*	
= 10 mg	QC:		Date:	_ SPC (Y/N):	D	ate:			Sı	top	*NI	R2*	
Sequence ID/ Work Center I	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		eject umber	Insp. Stamp	<del></del>
160		White Gloss(Ref 42.5.)	per QSI005 4.3-Alum	0.00				/	/	,	<i>4</i>	_	
*160* Powdercoat		Memo	. ,	0.00				<i></i>	Ø	/3	3-11-	2	DAS 34
Powder Coating		1- touch up 2- Plug hole	corner with alodine only es prior to						•				9-89
		OVEN TEN FINISH TIN	: ME: <b>7:55</b> MPERATURE: <b>35</b> ME <b>3: 37</b> ME3: <b>37</b>	cessary**********	****								
4		2ND COAT START TIN OVEN TEN	Γ: ME: MPERATURE:	·									
		rinisri ili	ME:										
170		QC3- Inspect Part Finis	<b>h</b> *	0.00				Ą		1	Λ. <b>/</b> . Λ	1	<i>.</i>
*170*			• .	0.00				l x	• {	<u></u>	YY_	13/13	1/2
QC; Quality Control		Memo		0.00					1	1			

NCR:	Yes	1	No
INCN.	162	,	110

DQA: \_\_\_\_\_ Date: \_\_\_\_

NCR: Ye	es / No				WORK ORDER NON-C	CONFO	JRIV	IANCE / UPI	DATE	QA Closed:	Date	e:
Work Orde	<b>.</b>				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap		N	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0	· · · · · · · · · · · · · · · · · · ·		<del></del>	Use-as-is Work Order Update	]   TI		oforming Large Fab	Finishing Composite	Rec/Stoi	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initi	al	Act	tion	Sign &		
Cause	Date	Step	Qty	!	or Non-conformance	Chief	Eng	Descr	ription	Date	Verification	QC Inspector
oc/Data												
quip/Tooling	_											
Operator							l					
Material	_	1					1					
etup		ľ					1					
Other												
rocess						Ì						
upplier												
raining		Ì				1						
Inapproved		<u> </u>				<u> </u>						
···				· · <del></del> · - <del></del>	F	AULT C	ATEC	ORY				
Landin	g Gear			_	General				_	7		<del></del> 1
	Bending			<u> </u>	Bend	$\vdash$	ain		<u> </u>	Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hai	rdwar	r <b>e</b>		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Ins	pection	on Incomplete	<u> </u>	Part Incorre	ct	Weld
	Crushed,	/Crimped		1	Burrs	lns	tructi	ions Incomplete/U	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
L	Cuffs			L	Contamination	Ma	ainte	nance		Part Moved		
ŀ	Heat Tre	at		L	Countersink	Mi:	slabel	led		Positioned V	Vrong	
	Inspection	n Strip in	Tube		Cut Too Short	Mis	sread			Power Loss/	Surge	Other
	Ripples i	n Bend			Drill Holes	Off	fset					
	Torque \	Vaves in l	Extrusio	n [	Drawing	Ou	it of C	Calibration				
	Turning	Sequence			Finish	Ou	it of S	equence				
	Wave/T	vist in Tul	be		Folio	Ou	ıtside	Dimensions				

May-13-13 1:04:11 PM

Item ID: Revision ID: Item Name:	D3915-041 Light Lid Ass	semby, Long Basket		Accept	*N900	040	100	)* s	Setup Sta	I VI	S1* S2*	
Start Date: Required Date:	5/09/13 : 5/13/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Reference:							=	· •	S. Sta			
Approvals:		an:		Tooling: SPC (Y/N):		ate:		ŀ	Run Sta Sto	IXI	R1* R2*	
Sequence ID/ Work Center II	D	Operation Description Assemble as per dwg		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	-
*180* HandFinish Hand Finishing		Memo	ebbing as per dwg	0.00				1x		) II	- 13/11	V
		2- Install pl	acard and label as per dwg									
190		QC5- Inspect part comp	leteness to step on W/O	0.00				1			10As 05,13.1	./
*190* QC Quality Control		Memo		0.00							. <u>05</u> / 15·/	11:13
200		Identify as per dwg & St	tock Location: <u>w</u> [5	ر ل ط <sub>00.0</sub>	030,043	13	101	50°			40 - (	
*200* Packaging		Мето		0.00		( 10			10	<u></u>	elhe	14
Packaging												

NCR:	Yes	1	No
INC.D.	162	,	INU

										DQA:	Date	:
NCR: Ye	s / No				WORK ORDER NON	-COi	VFORM	MANCE / UPI	DATE	•		· · · · · · · · · · · · · · · · · · ·
										QA Closed:	Date	:
Work Order	·•				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIR Older	•				Rework	╗╽		Skid-tube	Crosstube	]	Water Jet	Engineering
Part No	o.				Scrap	$\dashv$		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is			noforming	Finishing	-1	re/Packaging	Other
NCR No	o				Work Order Update			Large Fab	Composite	]	Supplier	
Root		T		Dosc	ription of work order update		nitial	Λ <sub>C</sub>	tion	Sign &		
Cause	Date	Step	Qty	Desci	or Non-conformance		ief Eng		ription	Date	Verification	QC Inspector
oc/Data	Date	Step	Qty		or Non comormance		ner Eng	26361	TIPETOTI	Dute	Vermedelon	Qe inspecto.
quip/Tooling	_	ļ										
perator	$\dashv$											
Material	7					1						
etup	7											
Other												
rocess											!	
Supplier												
raining		1								:		
Inapproved												
						FAUI	T CATE	GORY				
Landing	g Gear			_	General		-			-		<del></del>
	Bending			<u> </u>	Bend		Grain			Ovalized	L	Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa			Over/Under	tolerance	Temperature/Cure
L	Cracks				Broken/Damaged	<u> </u>	4	ion Incomplete		Part Incorred	<del>-</del>	Weld
_	Crushed/	Crimped		<u> </u>	Burrs	<u> </u>	4 .	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
_	Cuffs			L	Contamination	<u> </u>	Mainte		_	Part Moved		
1	Heat Trea				Countersink	$oxedsymbol{oxed}$	Mislabe		<u> </u>	Positioned V		<del>- ,</del>
_	Inspectio	-	Tube	_	Cut Too Short	<u> </u>	Misread	d	L.	Power Loss/	Surge	Other
	Ripples ir			L	Drill Holes		Offset					
<u> </u>	Torque V			n	Drawing	Ŀ	4	Calibration				
<u> </u>	Turning S			L	Finish		┥	Sequence				
	M/ave/Tu	vist in Tul	ha		Folio		Instead	Dimensions				

Work Ord  May-13-13 1:0		01533		*101533*								
Item ID: Revision ID: Item Name:	D3915-041	ssemby, Long Basket	,	Accept	*N900	<b>040</b>	100	*	Setup	Start Stop		S1* S2*
Start Date: Required Date Reference:	5/09/13 : 5/13/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		ate:		]	Run	Start Stop	1/1	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt	•	Reject Number	Insp. Stamp
*210 *210*		QC21- Final Inspection  Memo	- Work Order Release	0.00						3/1	1)1:	3

Memo

Quality Control

13/11/13 PM 13/1-13

NCR:	Yes	/	Nο

DQA: Date:

NCR: Ye	es / No				WORK ORDER NON-C	CONFO	IRIVIANCE / UP	'DATE	QA Closed:	Date	2. 
Work Order	••				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No	-				Rework Scrap		Skid-tube Machining	Crosstube Small Fab	-1	Water Jet d. Eng. Coor.	Engineering Quality
NCR No	D				Use-as-is Work Order Update	]   Th	ermoforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initia	1 Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Desc	cription	Date	Verification	QC Inspector
oc/Data	4										
quip/Tooling						Ì					
perator	_}										
/Jaterial	4						ļ			•	
etup	4	į									
Other	4									İ	
rocess	4		]								
upplier	_										
raining	-										
Inapproved		<u> </u>	<u> </u>			ALLIT	ATEGORY				
Landin					General General	AULI CA	RIEGORY				
Landin	Bending				Bend	Gra	in		Ovalized	Г	Pressure/Forced
	Centre No	ot Conco	ntric to (	\s	BOM/Route	<b>-</b>	dware		Over/Under	tolerance	Temperature/Cure
-	Cracks	or conce		"³	Broken/Damaged	$\boldsymbol{\vdash}$	ection Incomplete	-	Part Incorre		Weld
}	Crushed/	Crimned			Burrs	<b>—</b>	ructions Incomplete	/Unclear	Part Lost/M	<b>)</b>	Wrong Stock Pulled
<u> </u>	Cuffs	Cilliped		-	Contamination	<del></del>	intenance		Part Moved	B	
 	Heat Trea	at		<u> </u>	Countersink	<b>—</b>	labeled	_	Positioned \	Vrong	
 	Inspectio		Tube	-	Cut Too Short	<del></del>	read		Power Loss/		Other
<b> </b>	Ripples in			ļ	Drill Holes	Hoffs		<b>L</b>	٦. ٥٥. 2000/		1
<b> </b>	Torque V		Extrusion	,	Drawing	$\vdash$	of Calibration				
.	Turning S				Finish	$\vdash$	of Sequence				
<u> </u>	Wave/Tw	-			Folio	$\vdash$	side Dimensions				

Work Order ID: 101533

Parent Item:

D3915-041

Parent Item Name:

Light Lid Assemby, Long Basket

**Start Date:** 5/09/13

Required Date: 5/13/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC

10.04.20 verified by:EC

0.03.19 verified by:EC IPP Rev:B as per dwg revB DD IPP Rev:C add realodine DD 10.04.26 verified by:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2957. Mounting Plate		Manufactured	No			100	Each	19.0000	4 R1	2259	7 <del>&gt;</del> 4	/ <sub>x</sub>	
Woulding Frace				<b>Location</b>		Loc Qty	Lo	c Code				- <b>,</b>	
				WA004		19		_			0AS 43	13.	10.3
				8482	0	2					4.69	- <del>-</del>	_
\$ :.				9416		9							
				9427	0	8							
D3915-1		Manufactured	No			100	Each	13.0000	2	2			
Rib									B9	4452	>-2x		
				<b>Location</b>		Loc Qty	Lo	oc Code	_		040		
				WA004		2					43	10	
				9402	2	2					0AS 43	10.	10.31
				WA005		1							
•				8815	2	1							
				WA006		10							
				9445	2	10							
D4016-5		Manufactured	No			100	Each	14.0000	3	3			
Hinge Half, Light Lid		ivianatactarea							BI	0357	17 <del>-&gt;</del> .	3 <u>r_</u>	:
				Location		Loc Qty	Lo	oc Code			OA O	,	
				WA		12	<u> </u>				0AS 1	13	·10.3
				9427	1	12			-		2.89 /		
				WA004		2				<del></del>			
				8747	0	2			-	<u></u>			
D4019-3		Manufactured	No			100	Each	21.0000	3				,
Rib		Manufactured							<b>3</b> 5	74173	3		
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						21	<u> </u>	A COUL	,		43	13-	10.3
				WA006 9411	2	12			-		43		ن ح
				9411		9							

NCR:	Yes	1	No
		,	

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NCK. 1e	15 / NO				WORK ORDER NON-	COMPON	WIANGE / OF	DAIL	QA Closed:	Date	e:
Work Order					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No	-				Rework Scrap	- I	Skid-tube Machining	Crosstube Small Fab	4	Water Jet	Engineering Quality
NCR No	D	· · · · · · · · · · · · · · · · · · ·			Use-as-is Work Order Update	Theri	moforming Large Fab	Finishing Composite	Rec/Stol	re/Packaging Supplier	Other
Root	į			Descr	iption of work order update	Initial	Act	tion	Sign &		,
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desci	ription	Date	Verification	QC Inspector
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quip/Tooling	-	Ą							ļ		]
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/laterial	_										
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upplier	_	3.3									
raining		2									
Inapproved		* y . * Kr						<del></del>			
						AULT CATE	GORY				
Landing	<del></del>				General	ГПс:.			Ovalized	Г	Pressure/Forced
-	Bending			o,	Bend BOM/Route	Grain			Over/Under		<del></del>
-	Centre N	ot Conce	ntric to	<sup>0/3</sup>  -	BOM/Route	Hardw		-	Part Incorre	F-	Temperature/Cure Weld
-	Cracks	/C=:======		-	Broken/Damaged	<b>—</b>	tion Incomplete tions Incomplete/	Unclose —	Part Lost/M	<b>-</b>	Wrong Stock Pulled
ļ	Crushed/	,		-	Burrs Contamination	<b>—</b>	enance	Unclear	Part Moved	~ L	
-	Cuffs Heat Treat			-	Countersink	Mislab			Positioned V		
-	Inspection		. Tubo	<u> </u>	Cut Too Short	Misrea		:	Power Loss/	· · ·	Other
-	Ripples in	-	iube	-	Drill Holes	Offset	iu		Trower ross/	ourge [	Toulei
-	Torque V		Evtrusio	<u>,</u>	Drawing	$\vdash$	Calibration				
-	Turning			" - ├	Finish	$\boldsymbol{\vdash}$	Sequence				
}	Wave/Tv			-	Folio	-	e Dimensions				
	100000/10	Transfer in a City		E E	1. 5.15	1 10000					

Picklist Print
May 13-13 1:04:10 PM

Vork Order ID: Parent Item:	101533 D3915-041						Start I	Date: 5/09/13		Required 3	Date: 5/13/13
arent Item Name:	Light Lid Assemby,	Long Basket						Qty: 1.00		_	Qty: 1.00 *
D4029-041 Webbing (Long Basket)	,,	Manufactured	No		180	Each	5.0000	1	1	94084	DAS 32
veoling (Long Basket)				Location	Loc Oty		Loc Code			1-1-0	<del>9-89</del>
			÷				Loc Code				
	1 +1			ST489 94089	5						
ling of the	///		NI-	94089			0.0000				
04035-045	4	Manufactured	No _		100	Each	0.0000	1	1		•
	elight)		No		100	Each	2 0000 1	01	7		w. wise was plant.
D4035-047 Lid Rib Assembly, Aft (L	: -1-4)	Manufactured	NO		100	Eacii	2.0000	\$ 100	442		
LIG KID ASSEMBLY, ATI (L	ignt)			_					1—1 OC	~~	· · · · · · · · · · · · · · · · · · ·
				Location	Loc Qty		Loc Code			0AS 43 2-89	13-10-31
				WA005	2					43 8-89	
<u>(</u> '				87406	2						
D4056-1		Manufactured	No		100	Each	21.0000	B8	5	1/	
Label Plate								-120	رب ر		
				<b>Location</b>	Loc Oty		Loc Code			DAS:	
				WA004	21					43.1	13-10-3
				85016	18					4 8-89 V	
L. L				87247	3						
MS20600-AD4W3	,	Purchased	No		180	Each	1,123.0000	34	34		DAS
Cherry Rivets	1051								, /	3.0	32
' C	1051 1657-011			Location	Loc Oty		Loc Code	(n)	126	664	9-89
* *	1000			ST311	990		•				13/11/12
				122151	4						
	•			122452	4						
			*	123525	294						
				124231	688			<del></del>			
				WA003	. 133						
					133						

NCR:	Yes	/	No

DQA: \_\_\_\_ Date: \_\_\_\_\_

NCR: Ye	es / No				WORK ORDER NON-C	LONFO	KIVIANCE / UF	DATE	QA Closed:	Date:	
Work Order					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0				Use-as-is Work Order Update	Th	ermoforming Large Fab	Finishing Composite	Rec/Stoi	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initia	1 A	ction	Sign &		
Cause	Date	Step	Qty	+	or Non-conformance	Chief E	ng Des	cription	Date	Verification	QC Inspector
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quip/Tooling						1					
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/laterial		\ \frac{1}{2}									
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rocess	_										
upplier	╡.					1					
raining	4	4.									
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						AULI CA	TEGORY			<u> </u>	
Landin F				_	General	Gra	: <u></u>	Г	Ovalized		Pressure/Forced
-	Bending			~ <del> </del>	Bend BOM/Route	$\vdash$		-	Over/Under	talaranaa	Temperature/Cure
-	Centre N	ot Conce	ntric to (	<sup>3/5</sup>  -	BOM/Route	$\boldsymbol{\vdash}$	dware	-	<b>⊣</b>	<b>-</b>	Weld
	Cracks	(C.:		F	Broken/Damaged	_	ection Incomplete	/Unclose	Part Incorre	<b>—</b>	Wrong Stock Pulled
	Crushed	Crimpea		<del> </del>	Burrs	$\vdash$	ructions Incomplete Intenance	- Indicieal	Part Moved	12211.IR	Wrong Stock Pulled
-	Cuffs	_+		$\vdash$	Contamination	<b>  </b>	abeled		Positioned V	Mrong	
	Heat Tre		Tubo	-	Countersink Cut Too Short	Miss		-	Power Loss/		Other
-	<b>—</b>	on Strip in	rube	$\vdash$	Drill Holes	Offs		L	Trower ross/	Juige	Other
}	Ripples		Essteria i es	<u> </u>	Drawing	$\vdash$	of Calibration				
-		Vaves in I		'  -	Finish	<b>  </b>	of Sequence				
}		Sequence		-	Folio	$\vdash$	or sequence side Dimensions				
	[wave/11	wist in Tul	ne	1	ורטווט	I Jour	side Dimensions				

May-13-13 1:04:11 PM

Work Order ID:

101533

Parent Item:

D3915-041

Parent Item Name:

Light Lid Assemby, Long Basket

NAS1149DN416

Purchased

No

**Start Date:** 5/09/13

Required Date: 5/13/13

Start Qty: 1.00

Required Qty: 1.00

DAS

Washer

DSI 9657-01 MF (3-7-9

Location ST293

122151 124326 124968 124983

180

Loc Qty

1239 7

466

166

600

Loc Code

1,239.0000

Each

											DQA:	Date:	<b>)</b>
NCR:	/es	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UF	PDATE			
											QA Closed:	Date:	
Work Orde	or.					DISPOSITION	,			AGAINST DE	PARTMENT	/PROCESS	
***************************************	•	:				Rework	1	1	Skid-tube	Crosstube	]	Water Jet	Engineering
Part N	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is	1	ł .	noforming	Finishing	4	re/Packaging	Other
NCR I	No.					Work Order Update	1		Large Fab	Composite		Supplier	
										-			
Root						ption of work order update	1	Initial		ction	Sign &		
Cause		Date	Step	Qty	•	or Non-conformance	Ct	nief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling									:				
Operator													
Material													:
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Other													
Process							1						
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Landi	ng (	Gear				General	_	_			-		_
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		Centre N	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved	<u> </u>	_
		Heat Trea	at			Countersink		Mislabe	eled		Positioned V	<b>V</b> rong	
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	d .		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

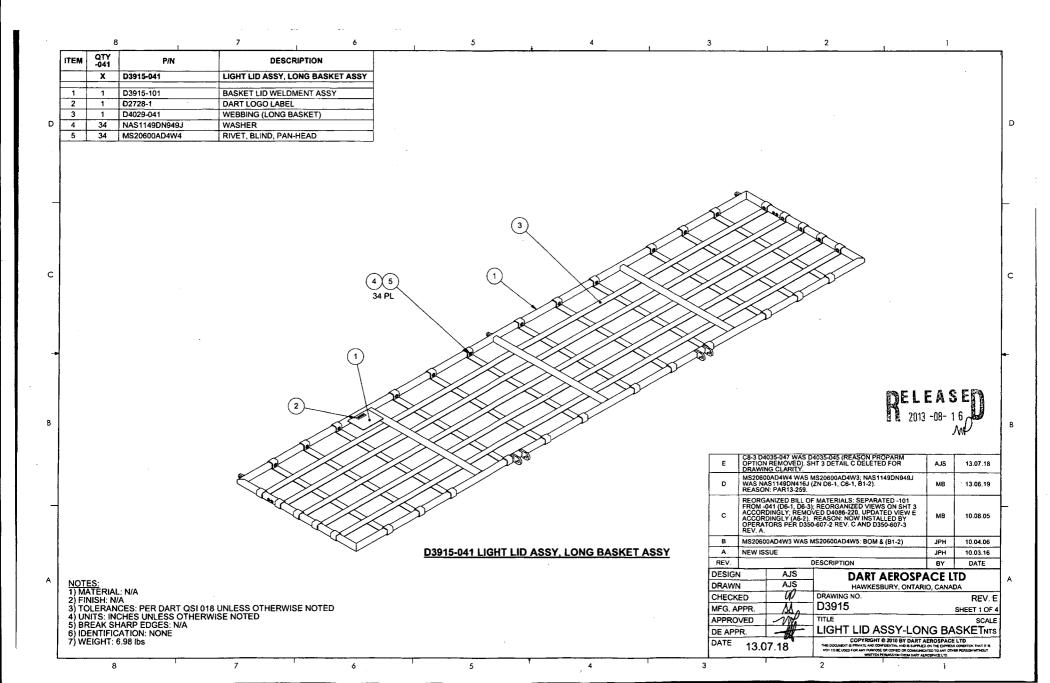
Drill Holes

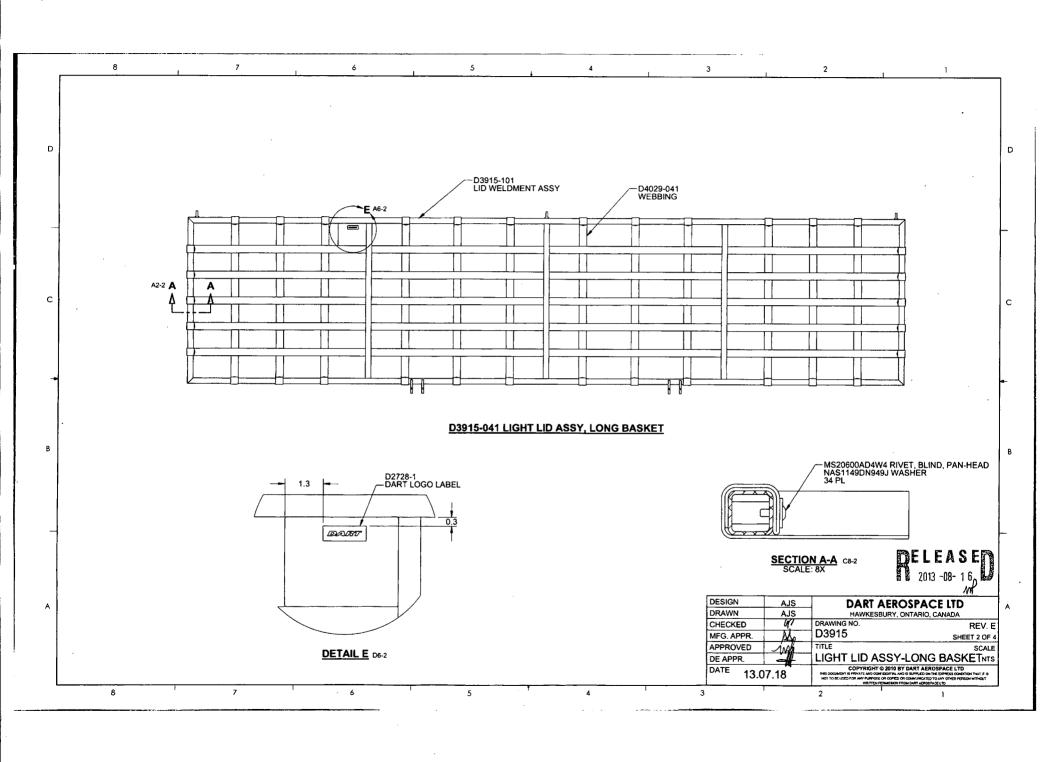
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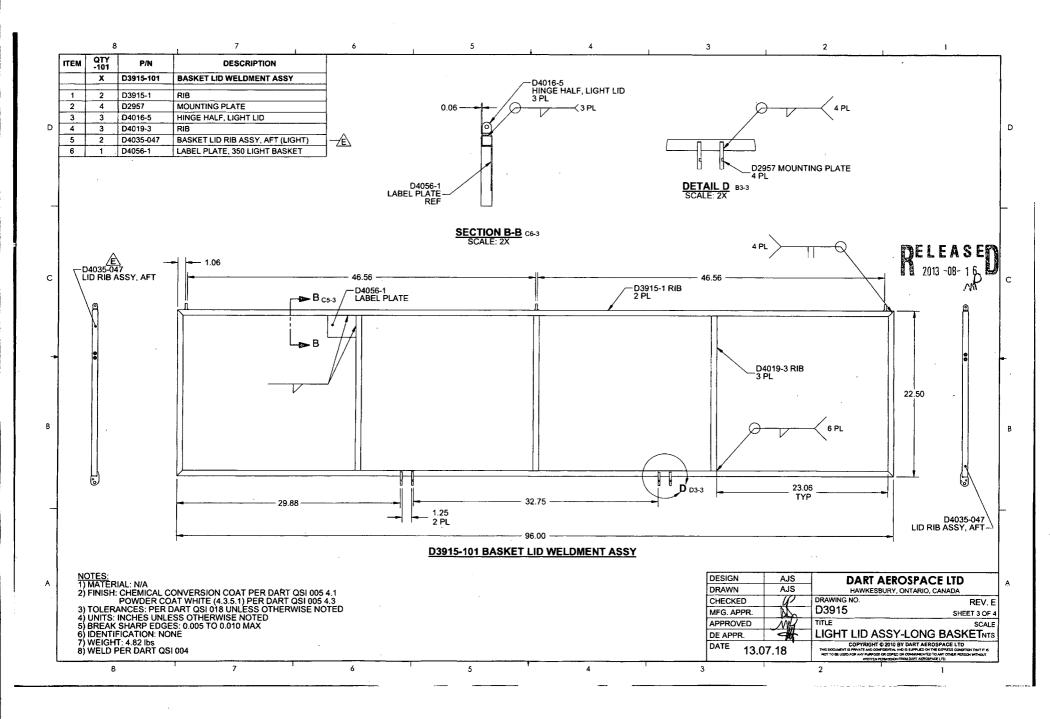
Finish

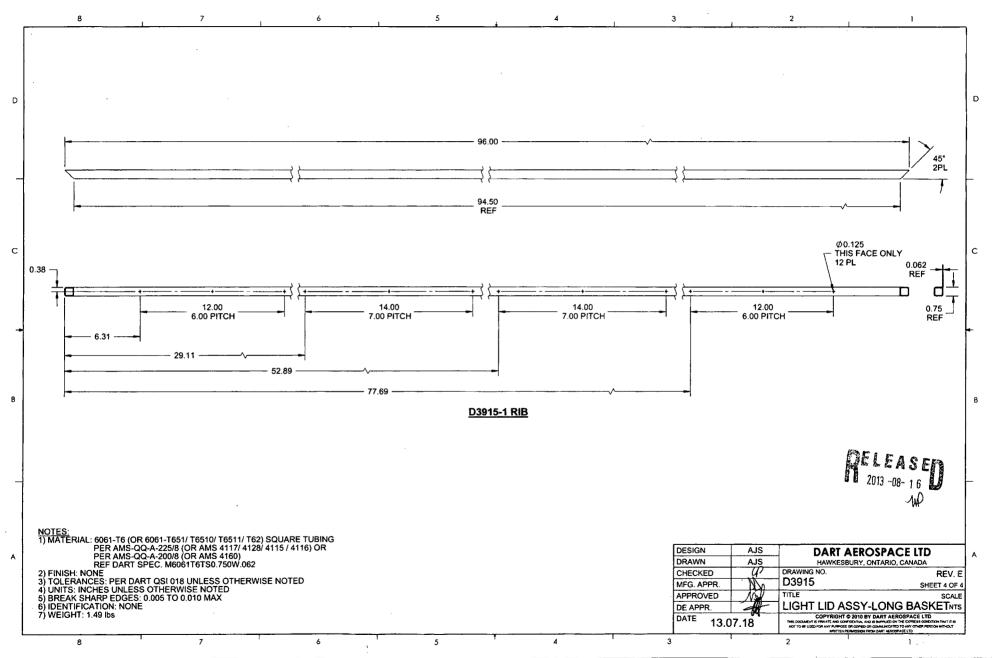
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## **DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS D350-807-2 REV. C AND EARLIER, INSTALLATION INSTRUCTIONS D350-807-3 REV. A AND EARLIER, AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607 REV. 4 AND EARLIER

REF. TCCA STC: SH94-14 REF. FAA STC: SR00213NY REF. EASA STC: EASA.10016996

REF. ANAC STC'S: 2007S03-03/-04/-05/-06

## 1.0 PURPOSE:

It has come to DART's attention that the webbing strands of the cargo net riveted to the structure of the lightweight lids on D350-607-443/-447/-543/-547 Heli-Utility-Baskets at CHG 004 and earlier may pull through the small washer and rivet head and detach during operation.

The purpose of this service instruction is to provide parts and instructions to replace the NAS1149DN416J Washers and MS20600AD4W3 Rivets fastening the webbing strands of the cargo net onto the structure of the lightweight lids with NAS1149DN949J Washers and MS20600AD4W4 Rivets.

Note: This change has been incorporated at a manufacturing level on D350-607-443/-447/-543/-547 Hell-Utility-Baskets at CHG 005 and subsequent and on D350-607-417/-419 Lightweight Lid Kits at CHG 003 and subsequent.

## 2.0 PROCEDURE:

- 2.1 Carefully remove existing rivets and washers attaching the webbing to the lid frame without enlarging holes in the webbing or the lid frame.
- 2.2 Inspect the basket lid structure in accordance with ICA-D350-607. It is acceptable to inject Sikaflex -241/-291 or Proseal 890 or MIL-S-8802 Class B2 sealant into the lid structure to trap rivet debris inside the tubular structure. Repair and touch up finish as required.
- 2.3 Inspect the D4029-041 Webbing (long basket) or D4029-043 Webbing (short basket) for wear. The maximum acceptable hole size is Ø0.188" (4.8 mm). Replace the webbing if holes are larger than Ø0.188" (4.8 mm) or if the webbing is worn or cuts have been found.
- 2.4 Re-install the webbing as shown in Figure 1 of this service instruction

  Note: It is acceptable to upsize rivets to MS20800AD5W4 (customer supplied) and enlarge the holes in the basket lid structure to Ø0.156" (3.96 mm) if holes were enlarged at Step 2.1.

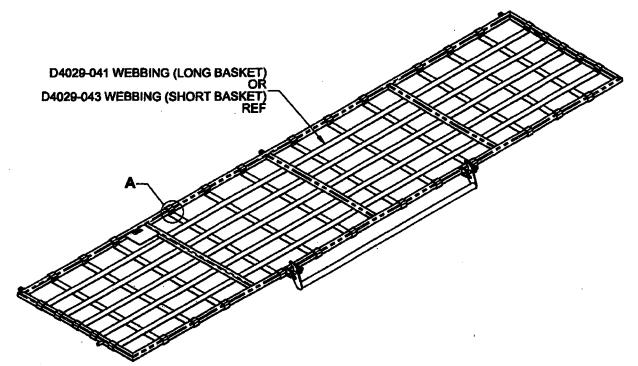
## 3.0 PARTS LIST

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI 9657-011	WASHER CHANGE (LONG LID)
<del></del>	X	DSI 9657-013	WASHER CHANGE (SHORT LID)
34	30	MS20600AD4W4	BLIND RIVET
34	30	NAS1149DN949J	WASHER

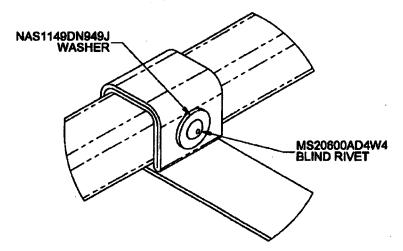
DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-0-01						
BY: D. SHEPHERD (DE # 02)						
DATE: 13.08.06 CERT. NO.: SH94-14 ISSUE NO.: 5						

CANADA

A	NEW IS	BUE		МВ	13.08.06	
REV.		<del></del>	DESCRIPTION	BY	DATE	
DESIGN DRAWN		X	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECKED		W	DRAWING NO.		REV. A	
MFG. APPR.		UA	DSI 9657		SHEET 1 OF 2	
APPRO	VED	UAD.	TITLE		SCALE	
DE APPR.			WASHER CHAN	GE	NTS	
DATE 13.06.06			THIS COGUSTENT IS PROVATE AND CONFIDENTIAL AV NOT TO SE USED FOR MAY PURPOSE OR COPIED O	COPYRIGHT © 2013 BY DART AEROSPÄCE LTD  THE DOUBLING B PRINTS AND GORDSONIAL WORD B SEPTED ON THE GORDSON COMMON THAT IT B  NOT TO BE USED FOR MY PURPOSE OR COPED OR CORMUNICATED TO ARY CITIED REPORTED.  HER THE COMMON SERVICE OR COPYRIGHT COMMON THE PROPERSON WITHOUT.		



## FIGURE 1: D3915-041 LONG BASKET LID ASSY (LIGHT WEIGHT) D4019-041 SHORT BASKET LID ASSY (LIGHT WEIGHT)



## **DETAIL A: RIVET/WASHER REPLACEMENT** 34 PL ON D3915-041, 30 PL ON D4019-041

**CANADA** DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO#01-0-01

APPROVED BY: NO D. SHEPHERD (DE # 02)

DATE: CERT. NO.: SH94-14 ISSUE NO .:

DRAWN CHECKED MFG. APPR. **APPROVED** DE APPR DATE 13.06.06

DESIGN

DART AEROSPACE LTD

DRAWING NO.

**DSI 9657** 

HAWKESBURY, ONTARIO, CANADA

REV. A

SHEET 2 OF 2 TITLE SCALE **WASHER CHANGE** 

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THE DOGAGEST SHYWAYE AND CONFERENTIAL AND IS ASPLED ON THE DEVELOP CONFIDENTIAL THE PARKET WITHOUT TO SE USED PORTANT FURPOSE ON LONGED OCCURRENTIATO TO ANY CHEST PERSON WITHOUT SHY